

Work Order ID 149396-2

July 22, 2016 3:10:55 PM

149396

Amo D
DRAB GREEN Page 1

Item ID: D3463-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Step

Stop *NS2*

Start Date: 9/19/2016 Start Qty: 46.00

46

Cust Item ID:

Required Date: 9/22/2016 Req'd Qty: 46.00

46

Customer:

Reference:

Approvals: Process Plan: 500 Date: 7/25/16 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3463	Rev B
-------	-------

100 FLOW WATER JET 0.00

100

Waterjet

Memo

0.61

FLOW CNC Waterjet

1-Cut as per Dwg D3463 Dwg Rev: B Prog Rev: B 2-
Debur if necessary

48

PR 2016/07/29
DAS
14 16/08/03
9-89

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Memo

0.08

Quality Control

48

PR 2016/08/02
DAS
14 16/08/03
9-89

120 QC8- Inspect parts - second check 0.00

120

QC

Memo

0.15

Quality Control

48

16-08-04

DAS
9
9-89

Work Order ID 149396

149396

Page 2

July 22, 2016 3:10:55 PM

Item ID: D3463-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step
 Start Date: 9/19/2016 Start Qty: 46.00 ***46*** Cust Item ID:
 Required Date: 9/22/2016 Req'd Qty: 46.00 ***46*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo 1-Form Dimples as per Dwg D3463 using DT3463-3T12-Debur3-Form as Dwg D3463.	0.03 0.92				<u>47</u>			AUG 24 2016 DAS 30 9-89
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.15				<u>47</u>			AUG 25 2016 DAS 38 9-89
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo *****STOCK IN LARGE FAB***** LOCATION: WA002	0.00 0.08				<u>County</u> <u>47</u>			AUG 26 2016 DAS 6 8-89

Work Order ID 149396***149396***

Page 3

July 22, 2016 3:10:55 PM

Item ID: D3463-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step

Start Date: 9/19/2016 Start Qty: 46.00

46

Cust Item ID:

Required Date: 9/22/2016 Req'd Qty: 46.00

46

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.77

Quality Control



AUG 23 2016

DAS
21
9-89

AUG 26 2016

Picklist Print

Page 1

July 22, 2016 3:10:55 PM

Work Order ID: 149396

149396

Parent Item: D3463-3

D3463-3

Parent Item Name: Step

Start Date: 9/19/2016

Required Date: 9/22/2016

Start Qty: 46.00

Required Qty: 46.00

Comments: IPP REV. A 05.11.18 NEW ISSUE EC
IPP Rev:B Now on Waterjet 056-08-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	90.2498	0.243	11.76632			

M304S16GA

304/316 Sheet.063

PR 2016/08/02

Location	Loc Qty	Loc Code
MAT010	73.75	
m134677	4.27	
m134982	5.48	
<u>m135061</u>	64	
TPI	16.499794	
m134604	16.499794	

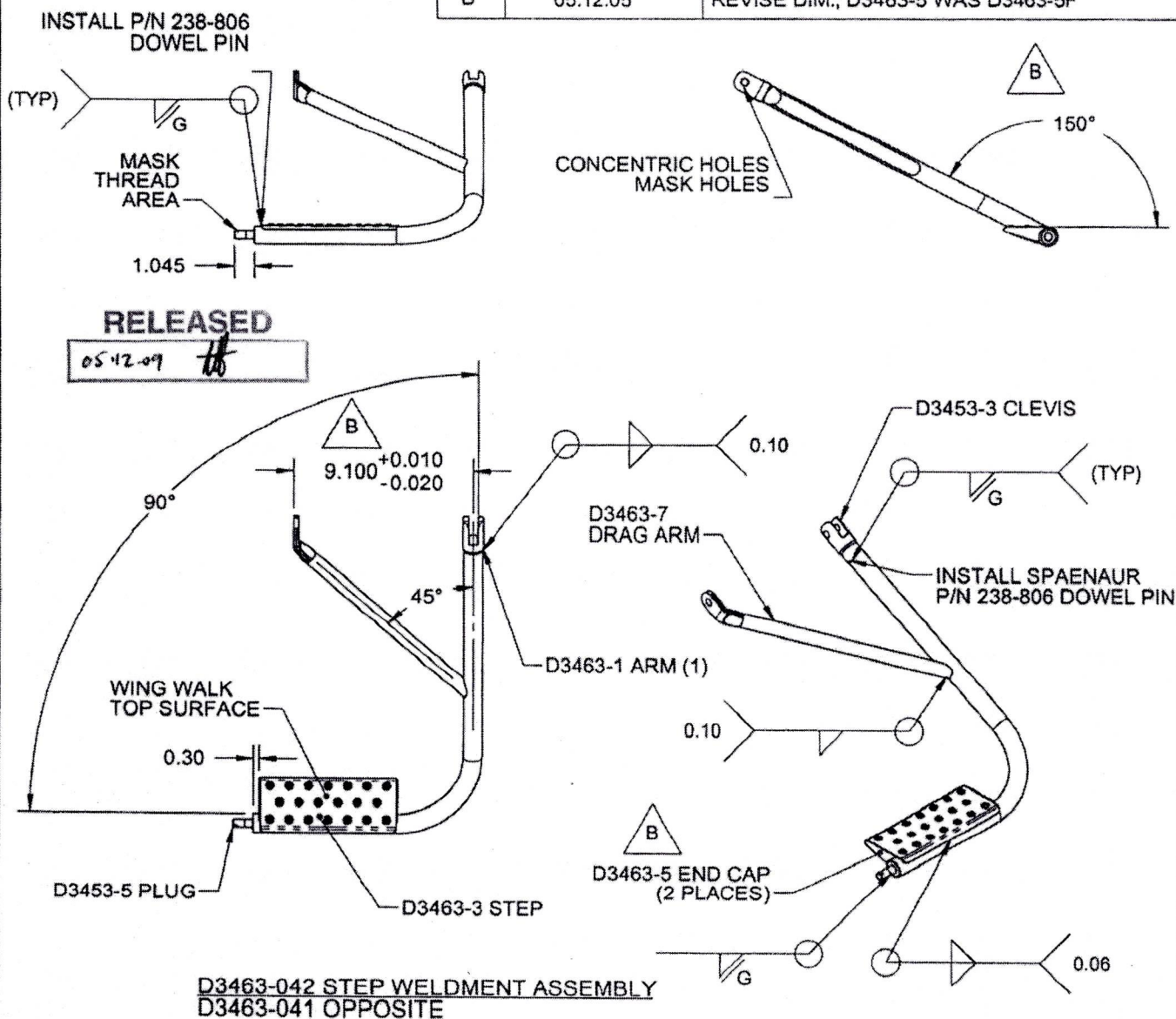
DAS
14
0-33 *16/08/03*

14



54 7/25/16 149376

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

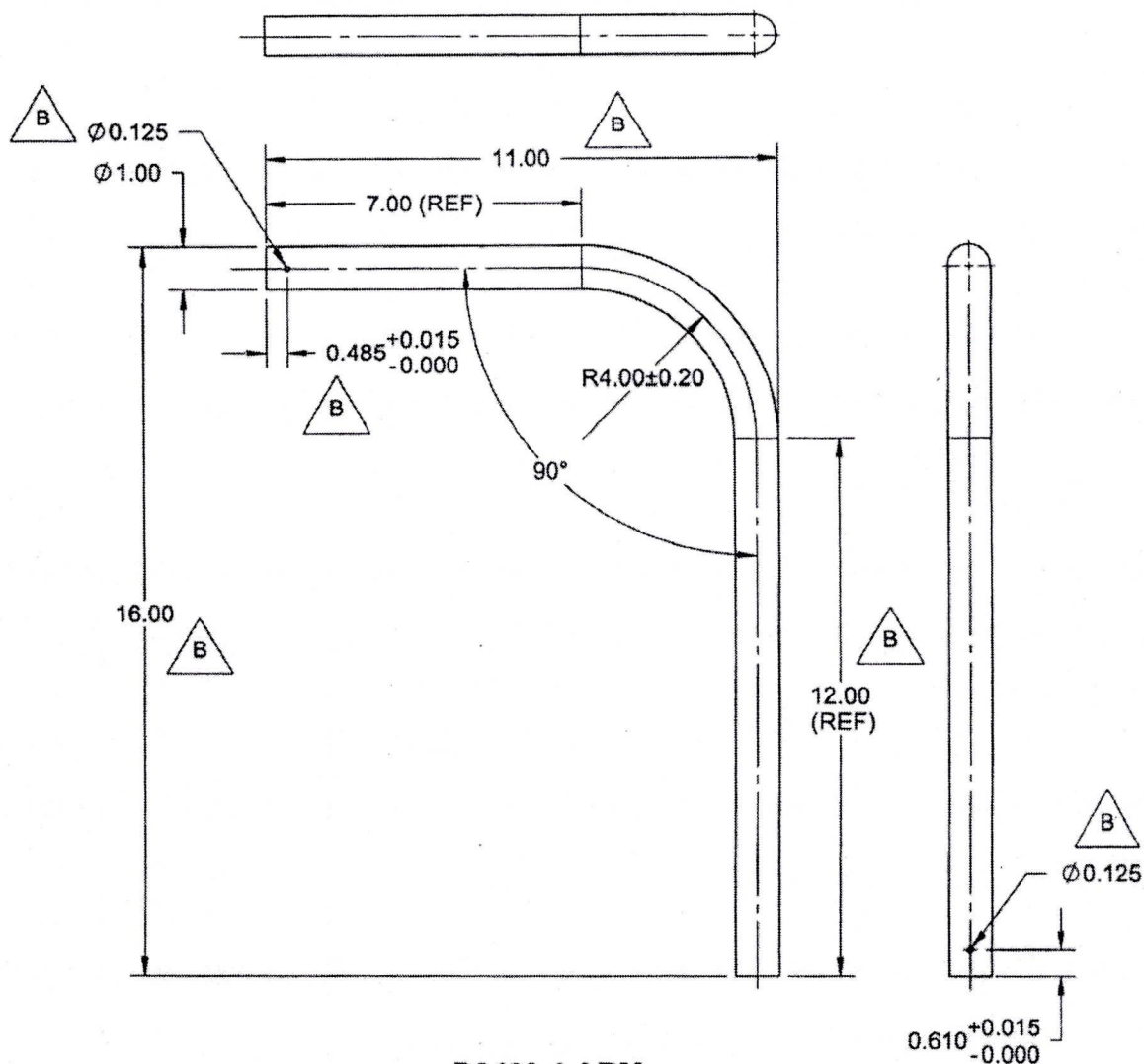
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.09



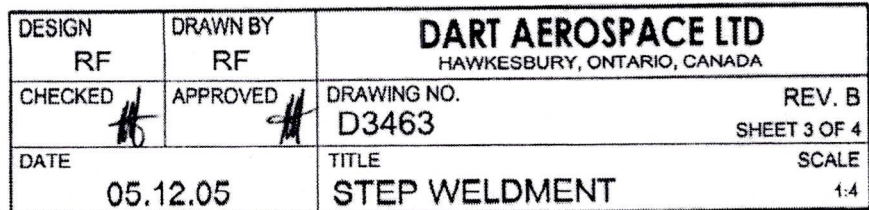
D3463-1 ARM

NOTES:

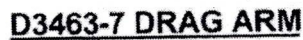
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



05.12.09



1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

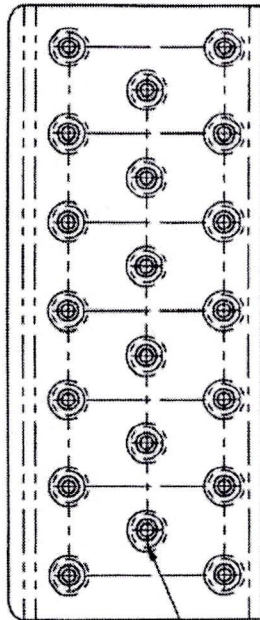
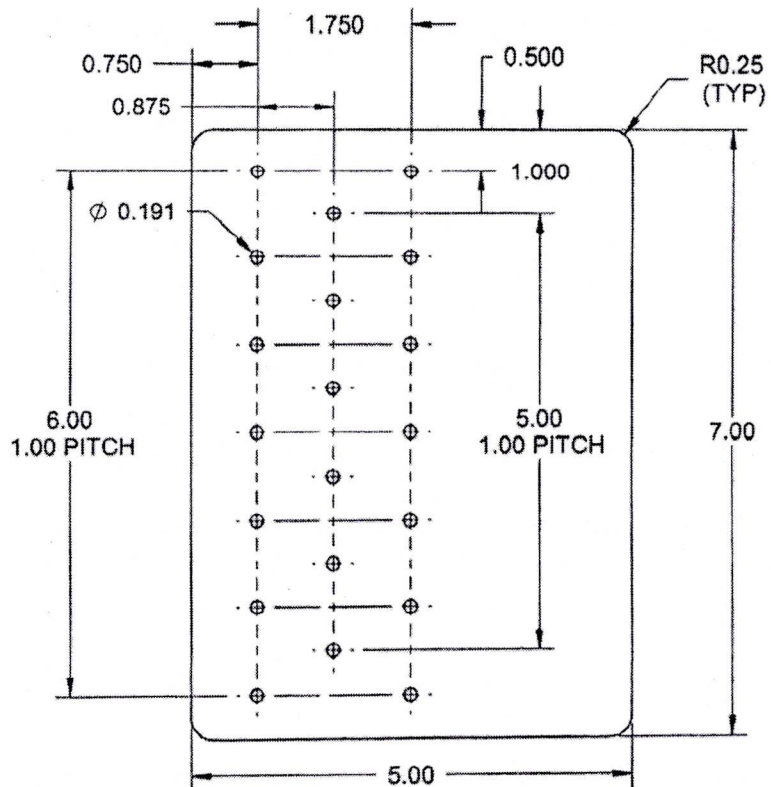
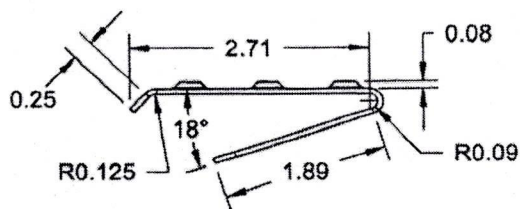
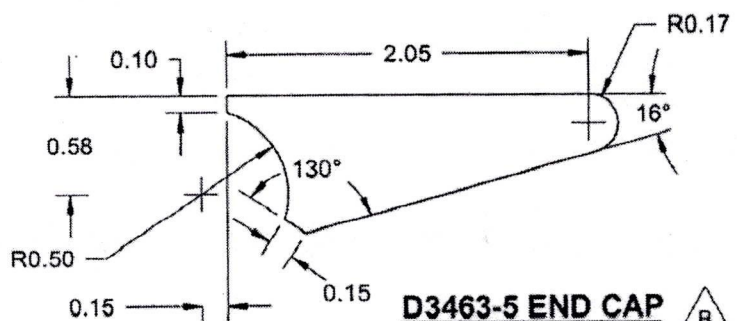
COPYRIGHT © 2005 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

05.12.05 #

**FORM USING
D3463-3T1****D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP
SCALE 1:1****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.